



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4419-1
Job Sheet 167942



Part No: D4419-1

Job Qty: 20 ea

Part Name: Fwd Support Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/8/17

Job Tracking No:

Due Date: 11/24/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	11/23/17	11/23/17	0.00	0.00	Start Up Waterjet1		SE
100	Waterjet	20 pcs	11/24/17	11/24/17	0.00	4.18	Waterjet1		SE
110	QC	20 pcs	11/24/17	11/24/17	0.00	0.00	QC2		SEAS
120	QC	20 pcs	11/24/17	11/24/17	0.00	0.00	QC8		SEAS
130	Packaging	20 pcs	11/24/17	11/24/17	0.00	0.00	Packaging3	stop	SEAS
140	QC21-SA	20 Ea	11/24/17	11/24/17	0.00	0.00	QC21		SEAS

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304S11GA	7	141	0	0

Part Specifications

Specifications could not be found.

Plex 11/8/17 11:46 AM dart.poulin.mario

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

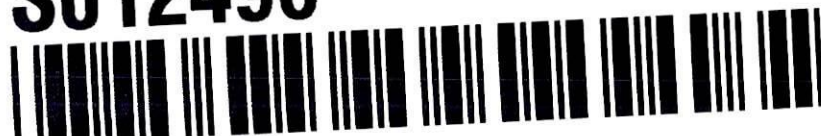
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		☐

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval
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Description Work Order Deviation

DART
AEROSPACE
S012496



Fwd Support Plate

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Completed By

Lead hand / Supervisor
Approval VerificationQC / QA Coordinator
Approval**PART NO:****D4419-1****Revision:****Operation:****Change No:****Start up Operation****Mfg Date: 11/22/17****Job No: 167942**

Root Cause							
Environment	☐	N	☐	Crushing	☐	Countersink	☐
Design	☐	O	☐	Heat Treat	☐	Cut Too Short	☐
Doc/Data	☐	O	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Equip/Tooling	☐	S	☐	Marks/Chatter	☐	Drill Holes	☐
Handling/Pre	☐	Tr	☐				
Material	☐	Us	☐				
Internal Transport	☐	Po	☐				
Tribal Knowledge	☐	Rushing	☐				
LOA	☐	Product Improvement	☐				
Substation	☐	Process Improvement	☐				
Past Expiry Date	☐	Manufacturing Process	☐				
Misidentified	☐	Past Due	☐	OTHER :			

ver Loss/Surge

o/Program

n

d

ng Stock Pulled

Out of Sequence

Off-set

Mislabeled

Fit/Function

Misaligned/off center

Positioned Wrong

Outside Dimensions

Over/Under tolerance

Part Incorrect

Part Lost/Missing

Part Moved

Drawing

Finish

Misread

Turning Sequence

DART AEROSPACE LTD	Work Order:	167942
Description: Fwd Support Plate	Part Number:	D4419-1
Inspection Dwg: D4419 Rev: A		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	Ø0.129				
Ø0.191	+0.005/-0.001	Ø0.193				
Ø0.250	+0.005/-0.001	Ø0.250				
Ø0.257	+0.006/-0.001	Ø0.258				
5.70	+/-0.030	5.713				
4.40	+/-0.030	4.417				
0.55	+/-0.030	0.561				
2.80	+/-0.030	2.804				
1.30	+/-0.030	1.315				
4.35	+/-0.030	4.361				
5.71	+/-0.030	5.722				
0.450	+/-0.010	0.451				
0.80	+/-0.030	0.812				
1.20	+/-0.030	1.215				
1.10	+/-0.030	1.116				
3.25	+/-0.030	3.267				
4.10	+/-0.030	4.117				
1.20	+/-0.030	1.208				
7.32	+/-0.030	7.331				
8.78	+/-0.030	8.792				
0.65	+/-0.030	0.663				
0.60	+/-0.030	0.614				
1.750	+/-0.010	1.751				
0.303	+/-0.010	0.304				
1.500	+/-0.010	1.500				
2.300	+/-0.010	2.301				
3.900	+/-0.010	3.901				
0.34	+/-0.030	0.356				
0.750	+/-0.010	0.751				
1.37	+/-0.030	1.381				
0.440	+/-0.010	0.441				
0.760	+/-0.010	0.767				
0.375	+/-0.010	0.374				

